

Date: Thursday, 20/12/2007 2:41:13 PM  
 User: Linda Lacelle

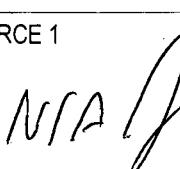
## Process Sheet

|                       |   |  |                  |                   |  |  |
|-----------------------|---|--|------------------|-------------------|--|--|
| Customer              | : CU-DAR001 Dart Helicopters Services   |  | Drawing Name     | : BAFFLE ASSEMBLY |  |  |
| Job Number            | : 36502   |  | Part Number      | : D3276041        |  |  |
| Estimate Number       | : 11264   |  | Drawing Number   | : D3276 REV B     |  |  |
| P.O. Number           | : N/A   |  | Project Number   | : N/A             |  |  |
| This Issue            | : 20/12/2007 S.O. No. : N/A   |  | Drawing Revision | : B               |  |  |
| Prsht Rev.            | : NC  |  | Material         | : N/A             |  |  |
| First Issue           | : N/A   |  | Due Date         | : 27/12/2007      |  |  |
| Previous Run          | : 36270   |  | Qty:             | 10 Um: Each       |  |  |
| Written By            | :  |  |                  |                   |  |  |
| Checked & Approved By | :  |  |                  |                   |  |  |
| Comment               | : Est Rev:A New Issue 05-12-06 JLM  |  |                  |                   |  |  |
|                       | Est Rev:B Now on Waterjet 06-09-06 JLM  |  |                  |                   |  |  |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description :   |   |
|---------|-----------------------|---|---|
| 1.0     | M6061T6S040           | 6061-T6 .040 Sheet  |    |
|         |                       |   |   |
|         |                       | Comment: Qty.: 1.0715 sf(s)/Unit Total : 10.7153 sf(s)<br>Material: 6061-T6 (QQ-A-250/11) 0.040" thick<br>(M6061T6S.040)<br>Batch: <u>105842</u> <u>B07-12-20</u> |   |
| 2.0     | WATER JET             | FLOW WATER JET  |  |
|         |                       |   |   |
|         |                       | Comment: FLOW WATER JET<br>1-Cut as per Dwg D3276<br>Dwg Rev: <u>B</u> <u>B07-12-20</u> <u>10</u><br>Prog Rev: <u>B</u>   |   |
|         |                       | 2-Deburr if necessary <u>B07-12-20</u>  |   |
| 3.0     | QC2                   | INSPECT PARTS AS THEY COME OFF MACHINE  |  |
|         |                       |   |   |
|         |                       | Comment: INSPECT PARTS AS THEY COME OFF MACHINE   |   |
| 4.0     | QC8                   | SECOND CHECK  |  |
|         |                       |   |   |
|         |                       | Comment: SECOND CHECK   |   |
| 5.0     | SMALL FAB 1           | SMALL & MEDIUM FAB RESOURCE 1   |  |
|         |                       |   |   |
|         |                       | Comment: SMALL & MEDIUM FAB RESOURCE 1  |   |
|         |                       | 1-Deburr   |   |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

## Process Sheet

|   |                         |  |
|---|-------------------------|--|
| Customer: CU-DAR001, Dart Helicopters Services  |                         | Drawing Name: BAFFLE ASSEMBLY  |
| Job Number: 36502   |                         | Part Number: D3276041  |
| Job Number:   |                         |   |
| Seq. #:   | Machine Or Operation:   | Description :  |
|   | 2-Roll as per Dwg D3276 | 83 07/n/26   |
| 6.0   | BRAKE NC                | NC BRAKE<br>                                  |
| Comment: NC BRAKE<br>Form as per Dwg D3276  |                         | 83 07/n/26   |
| 7.0   | QC5                     | INSPECT WORK TO CURRENT STEP<br><i>7/12-27 (16)</i>  |
| Comment: INSPECT WORK TO CURRENT STEP   |                         |   |
| 8.0   | HAND FINISHING1         | HAND FINISHING RESOURCE #1<br>                |
| Comment: HAND FINISHING RESOURCE #1<br>Chemical Conversion Coat as per QSI 005 4.1  |                         | BL 07/12-28  |
| 9.0   | POWDER COATING          | POWDER COATING<br>                           |
| Comment: POWDER COATING<br>Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  |                         | <i>m/06379</i> FL 07/12/28   |
| 10.0  | QC3                     | INSPECT POWDER COAT/CHEMICAL CONVERSION<br> |
| Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION  |                         | <i>m/08/01/03</i>  |
| 11.0  | D2464                   | 3/4 Seal<br>                                |
| Comment: Qty.: 2.2500 f(s)/Unit Total : 22.5000 f(s)<br>Pick:<br>Qty Part Number Description Batch<br>27.0" D2464 Neoprene Seal <i>B35433</i> |                         | <i>✓ ml 08/01/03</i>   |
| 12.0  | D32763                  | Decal<br>                                   |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)<br>Pick:<br>Qty Part Number Description Batch<br>1 D3276-3 Decal <i>M36523</i>     |                         | <i>✓ ml 08/01/03</i>   |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 2010/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 20/12/2007 2:41:13 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE ASSEMBLY

Job Number: 36502

Part Number: D3276041

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



x10

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3276

ml08/01/03

14.0 QC5

INSPECT WORK TO CURRENT STEP



08/01/03 x10

15.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 720

8/1/03 50 10x

16.0 QC21

FINAL INSPECTION/W/O RELEASE



10 08/01/04

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



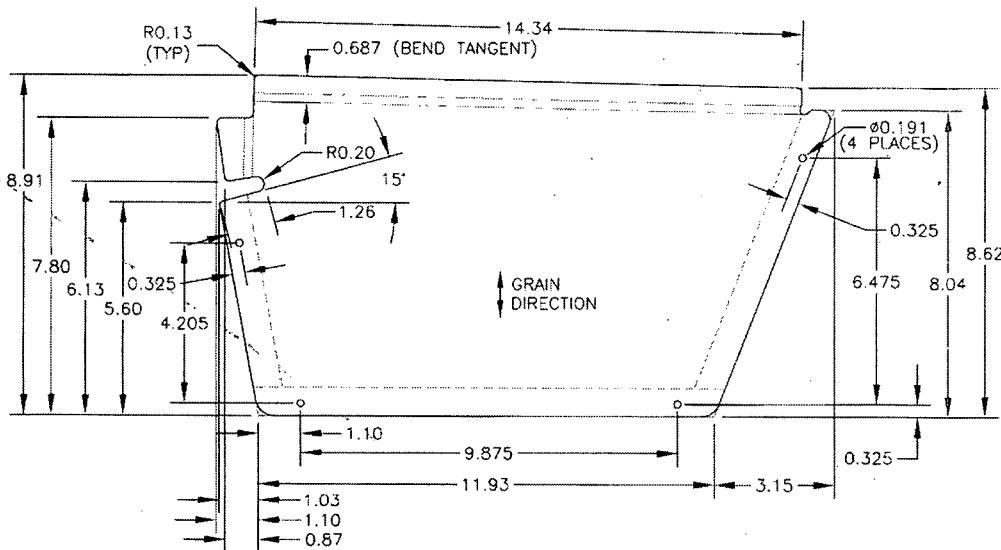
ml 2008/1/14  
W

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

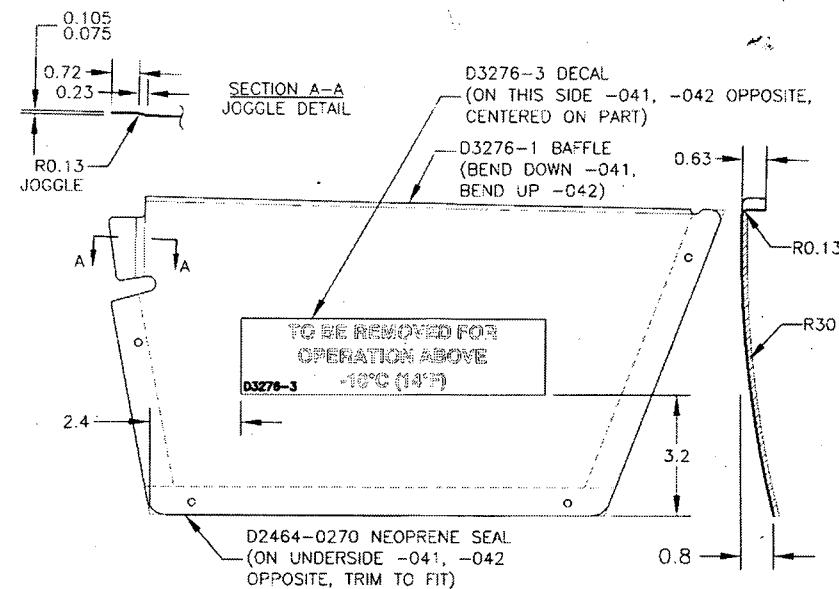
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

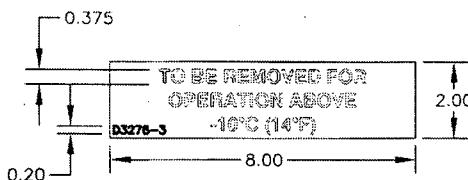


#### D3276-1 BAFFLE (FLAT PATTERN)

- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)  
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3276-041 BAFFLE ASSEMBLY, LH (SHOWN)  
D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)



#### D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

*03*  
03

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DART AEROSPACE LTD.

|          |          |                             |   |
|----------|----------|-----------------------------|---|
| B        | 05.01.25 | LABEL NOW -10°C; CURVE PART |   |
| A        | 05.01.07 | NEW ISSUE                   |   |
| DESIGN   | DRAWN BY | <b>DART</b>                 | DART AEROSPACE LTD.<br>HAWKSBURY, ONTARIO, CANADA |
| CP       | CP       |                             | REV. B  |
| CHECKED  | APPROVED |                             | DRAWING NO.                                       |
|          |          |                             | D3276   |
| DATE     |          | TITLE                       | SCALE   |
| 05.01.25 |          | BAFFLE ASSEMBLY             | 1:3   |

RELEASED  
05/02/06

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|                              |              |             |
|------------------------------|--------------|-------------|
| DART AEROSPACE LTD           | Work Order:  | 36502       |
| Description: BAFIE           | Part Number: | D3276       |
| Inspection Dwg: D3276 Rev: B |              | Page 1 of 1 |

## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

|                        |                       |                                |
|------------------------|-----------------------|--------------------------------|
| Measured by: <u>HS</u> | Audited by: <u>/</u>  | Prototype Approval: <u>N/A</u> |
| Date: <u>07-12-20</u>  | Date: <u>07-12-21</u> | Date: <u>/</u>                 |

| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A   |      | New Issue | KJ/JLM     |          |